

Work Order ID 59452

Friday, June 04, 2010 11:26:00 AM



Page 1

Item ID: D3573-3

Accept



Setup Start

Revision ID:

Item Name: Adapter

Stop



Start Date: 6/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-6-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3573

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.500" long

ant 10/06/06

10

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA673 and Dwg D3573

ant 10/06/07

10

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ant 10/06/07

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

ME



QC

Memo

0.00

10/06/07

10

0

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10/06/08

10

0

Hand Finishing

150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

10/06/08

10

0

Powder Coating

START TIME: *11:45am* OVEN TEMPERATURE:
FINISH TIME: *12:15pm* *320°F*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

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Item Name: Adapter

Start Date: 6/4/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 . 06 . 10 (10)

170

Identify as per dwg & Stock Location: 244

0.00



Packaging

Memo

0.00

Packaging

(X10) BB 10/06/14

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14 MF
10-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 11:26:05 AM

Page 1
T

Work Order ID: 59452



Parent Item: D3573-3



Parent Item Name: Adapter

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP Rev:A New Issue 07-01-29 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	15.8526	0.292	3.073684			



6061-T6 Bar .500 x 2.50

Location

Loc Qty

Loc Code

MAT02

15.8526

104366

15.8526

3.0736 *ml 10/06/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59452
Description: Adapter		Part Number:	D3573-3
Inspection Dwg: D3573 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.312	/			
2.69	+/-0.030	2.686	/			
2.31	+/-0.030	2.310	/			
1.600	+/-0.005	1.598	/			
0.36	+/-0.030	.358	/			
1.19	+/-0.030	1.188	/			
2.38	+/-0.030	2.376	/			
1.420	+/-0.010	1.418	/			
0.48	+/-0.030	.477	/			
R0.63	+/-0.030	R.630	/			
R0.13	+/-0.030	R.125	/			
R0.02	+/-0.030	R.020	/			
Ø0.209	+0.005/-0.001	Ø.213	/			
Ø0.266	+0.006/-0.001	Ø.271	/			
0.390	+0.010/-0.000	.395	/			
Ø0.675 x 0.190	+/-0.010	Ø.676 x .191	/			
Ø0.500 x 0.310	+/-0.010	Ø.502 x .310	/			

Measured by:	<i>[Signature]</i>
Date:	10/06/07

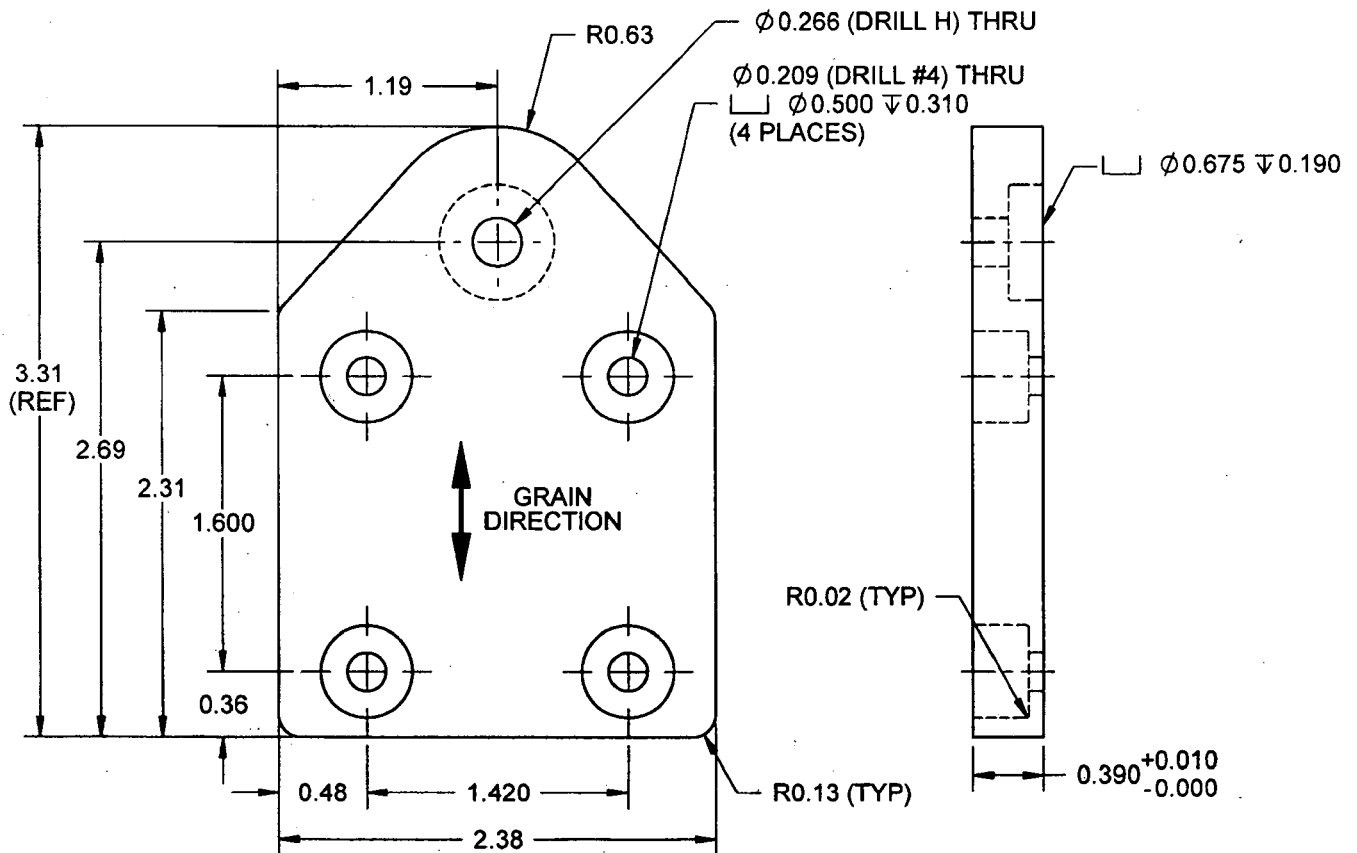
Audited by:	<i>[Signature]</i>
Date:	10/06/07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573 REV. A SHEET 2 OF 4
DATE 07.02.19	TITLE ADAPTER	SCALE 1:1

RELEASED
07 04 02**D3573-3 ADAPTER**

59452

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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